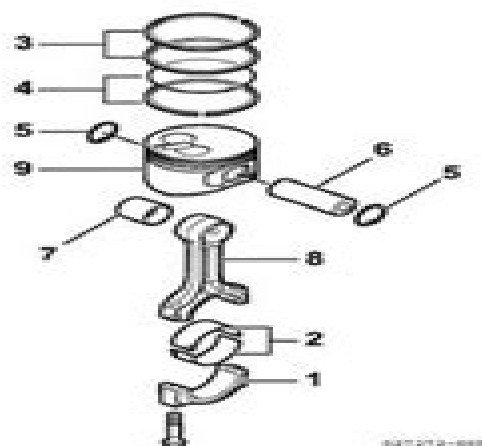


Assembling the Pistons

1. Select the parts needed to assemble the piston and connecting rod for one cylinder.
2. If removed, install a new wrist pin bushing (Figure 6-80, (7)) using a press and the appropriate service tool. Be sure to align the oil holes.

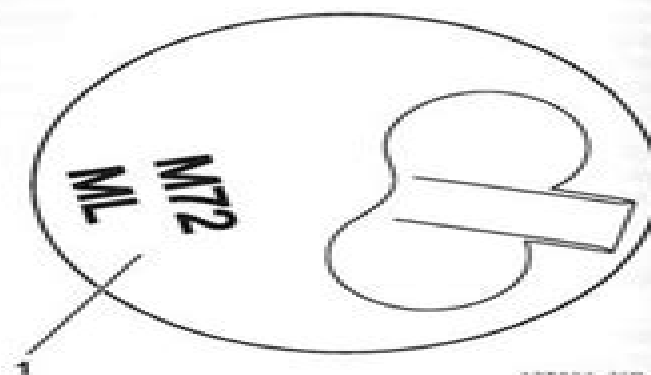
**Figure 6-80**

3. Install one circlip (Figure 6-80, (5)) into the piston. Ensure the circlip is securely seated in the groove.

NOTICE

The piston and connecting rod must be assembled with the correct orientation. When correctly assembled, the piston identification mark (Figure 6-81, (1)) stamped into the top of the piston will be on the opposite side of the connecting rod as the match marks (Figure 6-81, (3)) stamped into the connecting rod and connecting rod cap. When installed in the cylinder, the embossed mark (Figure 6-81, (2)) cast into the beam of connecting rod will face the flywheel end of the engine.

Note: The actual appearance of the match marks will vary but they will always be in the same locations.



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Figure 6-81

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**Eric Jorgensen, Alan Ahlstrand, John
Harold Haynes**



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